

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020377**Date Inspected:** 26-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Zhu Zong Hai		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector performed the following work:

Cross Beam CB11

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the East side DP to SP holdback weld.

ABF report # UT-CB11-004R1

The weld designations reviewed are as follows:

CB202A-011-001 and 003

Cross Beam CB11

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the West side DP to SP holdback weld.

ABF report # UT-CB11-005R1

The weld designations reviewed are as follows:

CB202A-011-013 and 015

Cross Beam CB11

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the East side BP to SP holdback weld.

ABF report # UT-CB11-006R1

The weld designations reviewed are as follows:

CB202A-011-004 and 006

Cross Beam CB11

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the West side BP to SP holdback weld.

ABF report # UT-CB11-007R1

The weld designations reviewed are as follows:

CB202A-011-016 and 018

OBG Segment 9AW-9BW

Shielded Metal Arc Welding (SMAW) in the 4G position of Crossbeam side BP to SP holdback weld # 9AW-SEG049A-012 & 9BW-SEG051A-045 as per CWR # 1852. The welders are identified as 047864. ZPMC Quality Control (QC) is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-Repair-1. See attached photograph Pic_001

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OBG Segment 9DW

Shielded Metal Arc Welding (SMAW) in the 4G position of Counterweight side LD web to flange weld # LD012-011 and 012 as per B-WR # 14757. The welders are identified as 067183. ZPMC Quality Control (QC) is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-Repair.



Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
